

Page 1

Insp.

September 27, 2010 8:00:40 AM Item ID: D206-667-103 Accept Setup Start Revision ID: . Stop Crosstube Fwd Item Name: Start Oty: 1.00 **Start Date:** 9/27/10 **Cust Item ID:** Required Date: 10/15/10 Req'd Qty: 1.00 **Customer:** Reference: Start Run Date: 10/9/2 Tooling: Process Plan: Date: Approvals: Stop QC: Date: Date: SPC (Y/N): Reject Sequence ID/ Operation Set Up/ Tool 1D Tool # Plan Accept Reject Work Center ID Description Code Qty Qty Number Stamp **Run Hours** Draw Nbr **Revision Nbr** D206-667-143 Rev C 100 0.00 DOCUMENT CONTROL Memo Photocopy bluefile and create labels as per PPP D206-667-103 Document Control Pick Kit 0.00 110 Packaging EZ 10-16-26 0.00 Packaging Memo

120

Packaging

CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

0.00

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-143 using CNC bender program

10-10-26 21

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
						-					

Part No: D206-667-10 3PAR #: No Fault Category: Crossolube

NCR Yes No DQA:

Date: 10.10.28

Resolution: SCRAP

Disposition: Scene

QA: N/C Closed: \_\_\_

NCR:62	313	We	ORK OR	DER NON-CONFORMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section B  Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
whole	1212	tube overbent due to mistake in the program. Program too strong operator error.	19/0/26 25/0/2	review all programs.		10.10.27	10/10/26 05/00/2	Subapa Subar

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Item ID:

D206-667-103

Accept



Setup Start

Stop



**Revision ID:** 

Item Name: Crosstube Fwd

**Start Date:** 9/27/10 **Required Date:** 10/15/10

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

\_\_\_ Tooling:

Date:

Tool ID

Run Start



QC:

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Date:

**SPC (Y/N):** 

Set Up/

**Run Hours** 

Date: \_\_

Tool # Plan

Code

Stop

Qty

Accept

Qty

Reject



Number Stamp

Insp.

Sequence ID/W Work Center ID

130

Memo

QC15- Crosstube Dimensional Check

0.00

0.00

Quality Control

Ma

Reject

W/O:			V	VORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CH	HANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ Fault Ca	itegory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	_ Disposit	tion:	QA: N/C	losed:		Date:	
NCR:		W	ORK OR	DER NON-CONFORMAI	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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Item ID:

D206-667-103

Accept



Setup Start



Stop

**Revision ID:** 

Item Name:

Crosstube Fwd

**Start Date:** 

9/27/10

QC:

Start Oty: 1.00

Required Date: 10/15/10 Req'd Qty: 1.00



**Cust Item ID: Customer:** 

Reference:

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Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Stop

Reject

Qty

Run



Sequence ID/ **Work Center ID** 

140



Crosstubes Crosstubes

**Operation Description**  Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty

Reject Number

Insp. Stamp

Crosstubes

0.00

0.00

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.

9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff(Donot engrave on outside of tube)

10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Resolution:		esolution:	Dispositio	າ:	QA:	N/C Clo	sed:		Date: _			
NCR:		,	WORK ORDI	ER NON-CONFORM	ANCE	(NCR)	)					
DATE	STEP	Description of NC			. 1 V			ation	Approval	Approval		
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Item ID:

D206-667-103

Accept



Setup Start

Stop



**Revision ID:** Item Name:

Crosstube Fwd

**Start Date:** 

9/27/10

Start Qty: 1.00

Req'd Qty: 1.00

Date:

**Cust Item ID:** 

Tool ID

**Customer:** 

Reference:

**Approvals:** 

Required Date: 10/15/10

Process Plan: Date:

**Tooling:** 

SPC (Y/N):

Date: Date:

Code

Tool # Plan

Reject

Qty



Sequence ID/

Work Center ID

150

HandFXtube

Hand Finishing Crosstubes

Operation Description

Crosstubes Chemical Conversion

Memo

Set Up/ **Run Hours** 

0.00

0.00 . ...

160

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

170

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Start

Stop

Run

Accept

Qty

Reject

Insp.

Number Stamp

W/O:			WO	ES							
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Resolution:			Disposition	:	_ QA: N/C CI	osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)					
DATE	STEP	Description of NC		on B	Verifi	cation	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Sect	ion C	Chief Eng	QC Inspector		
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Item ID:

D206-667-103

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Setup Start

Stop



**Revision ID:** 

Item Name:

Crosstube Fwd

**Start Date:** 

9/27/10

Start Qty: 1.00

Req'd Qty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Required Date: 10/15/10

Process Plan:

Tooling:

Date:

Run

Qty

Start



Date:\_\_\_\_\_

SPC (Y/N): Date:

Date:

Stop



Sequence ID/ **Work Center ID** 

Operation Description

Outsource process - NDT per QSI038 4.1

Set Up/ **Run Hours** 0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number

Insp. Stamp

180

Outsource2

Outsource process - NDT

Memo

0.00

CROSSTUBES

190

Packaging Packaging

Packaging

Memo

0.00

0.00

Ensure copy of NDT results attached to work order.

QC5- Inspect part completeness to step on W/O

200

Memo

0.00

0.00

Quality Control

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			- 4 - 1-4 -					
Part No		PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQA: _	Date: _	
Resolution: Disposition:					_ QA: N/C CI	osed:	Date: _	
NCR:			WORK ORI	DER NON-CONFORMA	ANCE (NCF	R)		
DATE	STEP	Description of NC			ion B	- Verificati	on Approval	Approval
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Item ID:

D206-667-103

Accept

Setup Start



**Revision ID:** 

Item Name: Crosstube Fwd

Required Date: 10/15/10

9/27/10

Start Oty: 1.00

Req'd Qty: 1.00

**Cust Item ID: Customer:** 

Tool ID

Reference:

**Start Date:** 

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AD	provals:

Process Plan:

Date:

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date: Date:

Tool # Plan

Code

Start

Stop



Sequence ID/

**Work Center ID** 

210

SprayPaint **Spray Painting**  SprayPaint

**Operation** 

Description

0.00

0.00

PRIME:

Finish Time:

220

Quality Control

0.00

0.00

Wrap in plastic bag to protect from scratches

Run

Accept

Qty

Reject

Qty



Stop

Reject

Number

Insp.

Stamp

Date:

Memo

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per OSI 005 4.2

Start Time:

Fininsh Time:

PAINT:

Start Time:

QC14- Inspect Spray Paint

Memo

W/O:			W	ORK ORDER CH	ANGES				
DATE	STEP	PRC	CEDURE CH	ANGE		Ву	Date Qty	Approvai Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	4	PAR #:	Fault Cat	egory:	NC	R: Yes N	o <b>DQA</b> :	Date:	
Resolution:				Disposition: QA: N/C Closed: Date:					
NCR:		\	WORK ORI	DER NON-CONFO	RMANCE	(NCR)	•		
DATE	STEP	Description of NC		Corrective Action	Section B	O: 0	Verification	Approval	Approval
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Item ID:

D206-667-103

Accept

Setup Start

Stop



**Revision ID:** 

Item Name: Crosstube Fwd

Required Date: 10/15/10

**Start Date:** 

9/27/10

Start Qty: 1.00

Req'd Qty: 1.00



Date:

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Stop

Start

Sequence ID/ **Work Center ID** 

230

Crosstubes Crosstubes

Crosstubes

Operation

Description

Set Up/ **Run Hours** 

SPC (Y/N):

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty** 

Reject Number Stamp

Insp.

Memo

0.00

0.00

(ASSEMBLE AS PER DWG D206-667-143)

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.

A/R Magnobond 6398:

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-

100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron

paint.

240

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

W/O:	•		ORK ORDER CHANG	FS	·····		·········		
DATE	STEP	PRO	OCEDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	tegory:	_ NCR: Yes	No DQ	A:	Date:		
Resolution:			Disposit	_ QA: N/C (	Closed:		Date: _	***	
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NC	R)			
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Item ID:

D206-667-103

Accept

Setup Start



**Revision ID:** 

**Item Name:** Crosstube Fwd

Required Date: 10/15/10

**Start Date:** 

9/27/10

Start Qty: 1.00 Req'd Qty: 1.00

Operation

Description

Pick Kit

Cust Item ID:

**Customer:** 

Tool ID

Reference:

A 1	opr	ava	le٠
A	սիա	uva	15:

Process Plan:

Date: Tooling:

Date:

Run

Reject

**Qty** 

Accept

Qty

Start

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N):

Set Up/

Date: \_\_\_\_\_

Tool # Plan

Code

Stop

Reject

Number Stamp

Insp.

Sequence ID/ Work Center ID

250

Packaging

Memo

**Run Hours** 

0.00

0.00

Packaging

260

OC4-100% Inspect kits for completeness

0.00

Memo

0.00

Quality Control

270

Packaging

Packaging

0.00

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev:

W/O:			V	VORK ORDER CHANG	SES			
DATE	STEP	PRO		CEDURE CHANGE			Qty Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	itegory:	NCR: Yes	No DQA:	Date:	
Resolution:								
NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	₹)		
DATE	STEP	Description of NC	Corrective Action		tion B	Verificat		
	J.C.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		C Chief Eng	QC Inspector
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Item ID:

D206-667-103

Accept



Setup Start



Stop

**Revision ID:** 

Item Name: Crosstube Fwd

**Start Date:** 

9/27/10

Start Qty: 1.00

Req'd Qty: 1.00

Operation

Description



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Tool # Plan

Code

Start

Reject

Qty

Run

Accept

Qty



Required Date: 10/15/10

OC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Stop

Reject

Number Stamp

Insp.

Sequence ID/

**Work Center ID** 

280

Quality Control

QC

OC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF 10-10-27

	•										
W/O:			V	VORK ORDER CHANG	ES						
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Resolution:			Disposit	tion:	QA:	N/C Clo	sed:	ed: Date:			
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DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval	
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September 27, 2010 8:00:40 AM

Work Order ID: 62313

Parent Item:

D206-667-103

Parent Item Name:

Crosstube Fwd



**Start Date:** 9/27/10

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:F $\square$ 05.09.01 $\square$ Add holes for compatibility with Bell Skidtubes $\square$ KJ/JLM

IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:

IPP Rev: H 08.11.17 QC5 was QC6 at step 12 KJ verified by: EC IPP Rev:1 08-12-15 add magnobond DD verified by:EC

IPP Rev J 09.01.06 ECN 08-562 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-667-103TRN		Manufactured	No			110	Each	2.0000	1	1 <i>E</i> Z	10-10-2	<b>L</b>	
Č				Location	<u>n</u>	Loc	<u>Oty</u>	Loc Code					
	ß	62632		LG	61426 61428		2 1 1		<u>-</u> -		<del>-</del> 		
D2873-043	HII 1111 III 181	Manufactured	No			230	Each	32.0000	2	2		· · ·	
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		•		LG	57337		12 12		_	<u> </u>			
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D2873-045		Manufactured	No			230	Each	28.0000	2	2			

 Location
 Loc Qty
 Loc Code

 LG
 28

 57336
 8

 60982
 . . . 20

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Nut Plate Assembly

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W/O:		•	W	ORK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	By Date Qty Appr Chief Prod			ng/ Approvar	
Part No:		PAR #:	Fault Cat	egory:	NCR: Ye	es No <b>DC</b>	A:	Date: _		
Resolution:			Dispositi	on:	_ QA: N/C	Closed:		Date: _	<u> </u>	
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DATE	STEP	Description of NC Section A	Initial Chief Eng				cation tion C	Approval Chief Eng	Approval QC inspector	
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September 27, 2010 8:00:40 AM

Work Order ID: 62313

Parent Item:

D206-667-103

Parent Item Name: Crosstube Fwd



**Start Date: 9/27/10** 

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

D2891-1

Manufactured

230

Each

57.0000

2

2.25 Support

<b>Location</b>	<u>Lo</u>	c Qty
LG		57
46159		. 7
50952		18
53773		20
55786		12
	230	Each

Loc Code 22.0000

D3595-063-395

Manufactured



RUBBER CUSHION

Location		Loc Qty	Loc Code
FP		10	
	44667	10	
ST	•	12	
	60585	12	

230

RUBBER CUSHION .63" x 3.95" (4)

MS20601-AD4W8

Purchased

Each

202.0000

14

14



RIVET

Location	Loc Oty
ST322	202
108521	98
112203	104

Loc Code

W/O:			M	ORK OR	DER CHA	NGES					
DATE	STEP	PRO	DCEDURE CH				By Date Qt			Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:P		PAR #:	Fault Ca	tegory:		NC	R: Yes	No <b>DQ</b>	A:	Date: _	
Resolution:											
NCR:		\	WORK OR	DER NON	I-CONFO	RMANC	E (NCF	₹)			
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September 27, 2010 8:00:40 AM

Work Order ID: 62313 D206-667-103 Parent Item: Required Date: 10/15/10 Parent Item Name: Crosstube Fwd **Start Date: 9/27/10** Start Qty: 1.00 Required Qty: 1.00 230 93.0000 M\$21920-20 No Each Purchased Clamp (per MIL-DTL-8783C) Loc Qty Location Loc Code LG 93 112624 2 114687 1 114779 14 115057 26 115736 50 250 86.0000 AN5-30A Purchased No Each **BOLT** Loc Code Location Loc Qty ST339 86 112933 11 114437 25 114941 50 332.0000 AN5-32A Purchased 250 Each No Bolt Loc Code Location Loc Qty 332 ST340 114056 72 114405 50 115016 50 115108 50 115589 60 115698 50

W/O:			V	VORK ORDER CHANG	GES						
DATE	STEP	PRO	OCEDURE CH			By Date Qty Appr Chief Prod				Approvai	
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Part No:		PAR #:	Fault Ca	tegory:	NCR:	Yes N	lo DQA	·	Date: _		
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NCR:			WORK OR	DER NON-CONFORM	ANCE (	NCR)					
DATE	STEP	Description of NC			ction B Verification Approv			Approval	Approval		
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# **Picklist Print**

September 27, 2010 8:00:40 AM

Work Order ID: 62313

Parent Item:

D206-667-103

Parent Item Name: Crosstube Fwd



**Start Date:** 9/27/10

10

10

18

12

Required Date: 10/15/10

Start Qty: 1.00

Required Qty: 1.00

AN5-7A



Bolt

AN960JD516

NAS1149D0563J Purchased

Purchased

Purchased

Purchased

Location

ST337 113149

Loc Oty

250

250

160 160 Each

Each

34.0000

160.0000

Loc Code

18

Washer

	ST		

No

No

No

Loc Qty Location 34 103694 18 107534 12 109287 4 250 Each

Loc Code

110.0000 · · 12

AN970-4

Wacher		

Location	<u>La</u>	Loc Qty			
ST349		110			
115266		10			
115531		50			
115621		50			
	250	Each			

957.0000

Loc Code

Nut

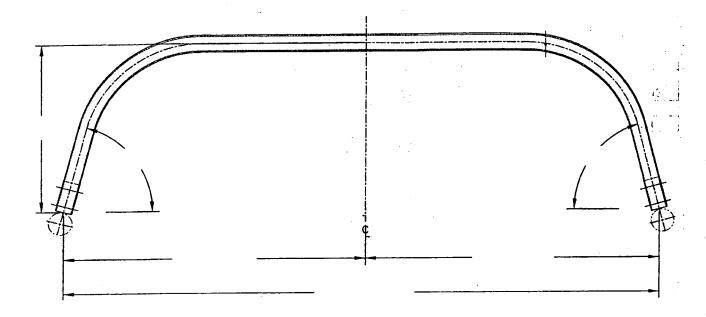
MS21042L5

Location		Loc Oty	Loc Code
ST139		26	-
11	14813	26	
ST300		931	
. 1	15156	431	
1.	15594	500	

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W/O:			V	ORK ORDER CHANG	GES			· · · · · · · · · · · · · · · · · · ·		
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DART AEROSPACE LTD	Work Order:	62313
Description: Crosstube High Fwd (206L)	Part Number:	D206-667-103
Inspection Dwg: D206-667-143 Rev: C		Page 1 of 1

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10



	Comments	

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	
В	09.06.26	Dimensions updated per Dwg Rev C	KJ	
С	09.10.22	Minimum height dimension revised	KJ	1/2
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Item Qtv Part Number Description -143 х D206-667-143 CROSSTUBE ASSEMBLY (206L HIGH FWD) D6002-115 CROSSTUBE NUT PLATE 3 D2873-043 4 2 D2873-045 NUT PLATE 5 2 D2891-1 SUPPORT D3595-063-395 RUBBER CUSHION 6 MS21920-20 CLAMP (OR MS21920-21) 4 8 MS20601AD4W8 RIVET (OR NAS9302B-4-8) 14 MAGNOBOND 6398 ROCKWELL SPECIFICATION RBQ-120-9 A/R 023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#### **GENERAL NOTES:**

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- 1) MATERIAL: MANUFACTURED FROM D6002-115
  - FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 15.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED, BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS, DEFECTS UP TO 0,005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

CX10/9/27 W10:62313



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С	REORG TO CUR D3595-0 REMOV RELOCA	ANIZED VIEWS RENT STAND/ 163-395 WAS D ED REF. & ADI ATED FLAG #6	ITES/PART LIST (ZN D7-1); S AND REFORMATTED DRAWING ARDS. 2856-400-694 (ZN D6-2 & A5-2); D TOLERANCE (ZN D3-3, C4-3, C5-3); (ZN A8-3) PER NCR 210; MOVED PDATED TOLERANCE TO SHEET 4.	RF	08.11.06				
B ADD HOLES AND NUT WITH BHT/AA SKUDTU			PLATES FOR COMPATABILITY JBES	PH	05.07.26				
Α	NEWIS	SSUE		CP	00.11.17				
RÉV.	REV. D		DESCRIPTION	BY	DATE				
DESIGN		P	DART AEROSPACE LTD						
DRAWN RF			HAWKESBURY, ONTARIO, CANADA						
CHECK	CHECKED (1)		DRAWING NO.	REV. C					
MFG. APPR.		8	D206-667-143						
APPRO	APPROVED /		TITLE	TLE SCALE					
DE APP	DE APPR.		CROSSTUBE ASSY (206L F	IIGH F	ND) NTS				
DATE	08.1	1.06	COPYRIGHT © 2000 BY DART AS THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED. NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICA WIGHTEN PERMISSION PRIOR DART ARE	ON THE EXPRESS	CONDITION THAT IT IS				

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